

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-007976**Date Inspected:** 21-Jun-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** WU ZHI CHENG**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

OUTSIDE SEGMENT ASSEMBLY AREA

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 1G position of the segment 4BW,weld No. SEG-19A-004. The welder is identified as #220069. The welding variables recorded by QC appear to comply with WPS- B – P-2231-B-U2a-F.

Flux Core Arc Welding (FCAW) in the 1G position of the segment 4BW,weld No. SEG-021A-007 . The welder is identified as #202841. The welding variables recorded by QC appear to comply with WPS- B – P-2231-B-U2a-F.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) of approximately 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

members are identified as 4BW & 4BE splice weld.

The Weld Designations are as follow

0BW4B-063~065

0BE4B-059&060

Visual Inspection

This QA Inspector was performed Visual inspection for Punch List at segment 4AE & 4BE ,which were request by Mr. Kevin Chen of ABF and ZPMC Quality Assurance Mr. Wang Lu for sign off of punch list .

The QA Inspector found total punch item was 29.

This QA Inspector verified the all area and only 4 item has comply the requirements, and remaining all item to be rectified from ZPMC.

Item were #861,863,864&887 signed off punch list, ABF/ZPMC were present.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Prue,Erik	QA Reviewer
